

Work Order ID 131491

Friday, April 10, 2015 7:55:51 AM

RLC

131491

Page 1

Item ID: D2842-041
Revision ID:
Item Name: Step Assembly, 206 Float

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 4/10/2015 Start Qty: 2.00 *2*

Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00 *2*

Customer:

Reference:

Approvals: Process Plan: M L S Date: 15-04-10 Tooling: Date:

Run Start *NR1*

QC: Date: SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2842	Rev B

100		0.00
-----	--	------

100

Large Fab

Large Fab

Memo

0.02

Large Fab

1-Cut D2842-1 using D2622 extrusion as per Dwg D2842
2-Drill D2842-1 using Jig DT8271 as per Dwg D2842 ***DO NOT OPEN HOLES***
3-Deburr and bevel ends for welding

2 SEP 02 2015 DAS 24 9-89

110	QC6- Inspect dimensions to drawing	0.00
-----	------------------------------------	------

110

QC

Memo

0.00

Quality Control

2 SEP 09 2015 DAS 24 9-89

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Item Name: Step Assembly, 206 Float

Start Date: 4/10/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: Date: Tooling: Date:
QC: Date: SPC (Y/N): Date:

Run Start ***NR1***
Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* Large Fab	Weld per dwg A/R Aluminum rod Batch: 130855 Large Fab	0.00				2		SEP 09 2015	DAS 24 9-89
	Memo	0.03							
Large Fab	1-Weld one end cap and (2) lugs using Jig DT10038 as per Dwg D2842								
	2-Grind end cap weld flush								
	3- Open hole as per dwg and deburr(0.250")								
130 *130* QC	QC9- Inspect visual per QS1004- Fusion Welds	0.00				2		DAS 43 9-89	SEP 10 2015
Quality Control	Memo	0.00							
140 *140* QC	QC5- Inspect part completeness to step on W/O	0.00				2		DAS 43 9-89	SEP 10 2015
Quality Control	Memo	0.00							

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Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.02

Hand Finishing

2 15-9-10

160

QC7-Inspect Chemical Conversion Coat

0.00

160

QC

Memo

0.00

Quality Control

2 15-09-10

170

Weld per dwg A/R Aluminum rod Batch: 130855.00

Large Fab

0.05

170

Large Fab

Memo

Large Fab

1-Remove alodine prior to welding.
Weld end cap as per Dwg D2842.
2-Grind end cap weld flush.

2 SEP 11 2015

DAS
24
9-80

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Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC10- Inspect visual per QSI004- ground welds

0.00

180

QC

Memo

0.00

Quality Control

SEP 14 2015

190

QC5- Inspect part completeness to step on W/O

0.00

190

QC

Memo

0.00

Quality Control

SEP 14 2015

191

Pressure Wash per QSI005 4.3

0.00

191

HandFinish

Memo

0.01

Hand Finishing

Touch up step with alodine per qsi 005 prior to powder coat

15-9-14

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Cust Item ID:

Required Date: 4/10/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
200	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
200	<i>m 131545</i>					2	15	9-16	<i>238</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>10:20</i>								
	OVEN TEMPERATURE: <i>320°</i>								
	FINISH TIME: <i>10:50</i>								
210	QC3- Inspect Part Finish	0.00							
210									
QC	Memo	0.00							
Quality Control									
220	HandFinishing	0.00							
220									
HandFinish	Memo	0.02							
Hand Finishing	1-Install inserts as per Dwg D2842								
	2-Wing Walk as per Dwg D2842 and QSI 005 4.1								
	Batch: <i>M132599</i>								

2x f ill 13/08/16

2x f ill 15/08/16

DAS
15
8-89

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Cust Item ID:

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
230	QC5- Inspect part completeness to step on W/O	0.00							DAS 38 9-89
230						(2)			SEP 17 2015
QC	Memo	0.00							
Quality Control									
240	Identify as per dwg & Stock Location: _____	0.00							
240						2			DAS 38 9-89
Packaging	Memo	0.00							SEP 18 2015
Packaging									
250	QC21- Final Inspection - Work Order Release	0.00							
250									
QC	Memo	0.00							MLJ
Quality Control									SEP 18 2015

MLJ SEP 18 2015

Picklist Print

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Parent Item: D2842-041

D2842-041

Parent Item Name: Step Assembly, 206 Float

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

NAS1149C0332R

Purchased

No

100

Each

5,554.000

3

6

NAS1149C0332R

WASHER

**

all 12/08/12

Location

Loc Qty

Loc Code

FP001

2174

123248

34

m130325

2140

x 6

GA

786

m131618

786

ST260a

2570

m131697

2570

ST271

24

m131340

24

D2622-120C

Manufactured

No

120

Each

151.9200

1

2

D2622-120C

Step Extrusion

**

SEP 02 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

151.92

125381

25.92

130161

126

2

D2734

Manufactured

No

120

Each

89.0000

2

4

D2734

Step End Plate

**

SEP 02 2015

DAS
24
9-89

Location

Loc Qty

Loc Code

WA003

89

130457

29

130983

60

3

Picklist Print

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Parent Item: D2842-041

Parent Item Name: Step Assembly, 206 Float

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D2842-041

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

D3459-3

Manufactured No

120

Each

48.0000

2

4

**

D3459-3

Float Step Mounting Plate

SEP 02 2015

DAS

24

9-99

Location

Loc Qty

Loc Code

WA003

48

125129

6

125762

6

126298

6

129735

10

130491

20

4

D3459-1

Manufactured No

220

Each

41.0000

2

4

**

D3459-1

Float Step Mounting Plate

SEP 02 2015

DAS

24

9-99

Location

Loc Qty

Loc Code

WA003

41

125376

6

126297

6

130003

12

130490

17

4

MS27039C1-07

Purchased No

220

Each

68.0000

3

6

**

MS27039C1-07

screw

all 13/09/12

Location

Loc Qty

Loc Code

ST283

68

m130566

18

m131624

50

M132317

x6

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Shop Packet Print

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Picklist Print

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D2842-041

Start Date: 4/10/2015

Required Date: 4/10/2015

Start Qty: 2.00

Required Qty: 2.00

NAS1329C3KB130

Purchased

No

220

Each

63.0000

3

6

NAS1329C3KB130

Insert

**

all 13/09/16

Location

Loc Qty

Loc Code

FP001

23

m129207

21

m130281

2

ST267

40

131677

40

X6

NAS1515H3L

Purchased

No

220

Each

421.0000

3

6

***NAS1515H3I ***

Washer

**

all 13/09/16

Location

Loc Qty

Loc Code

FG

40

102472

40

FP001

55

m127831

55

ST266

326

m127831

48

m130726

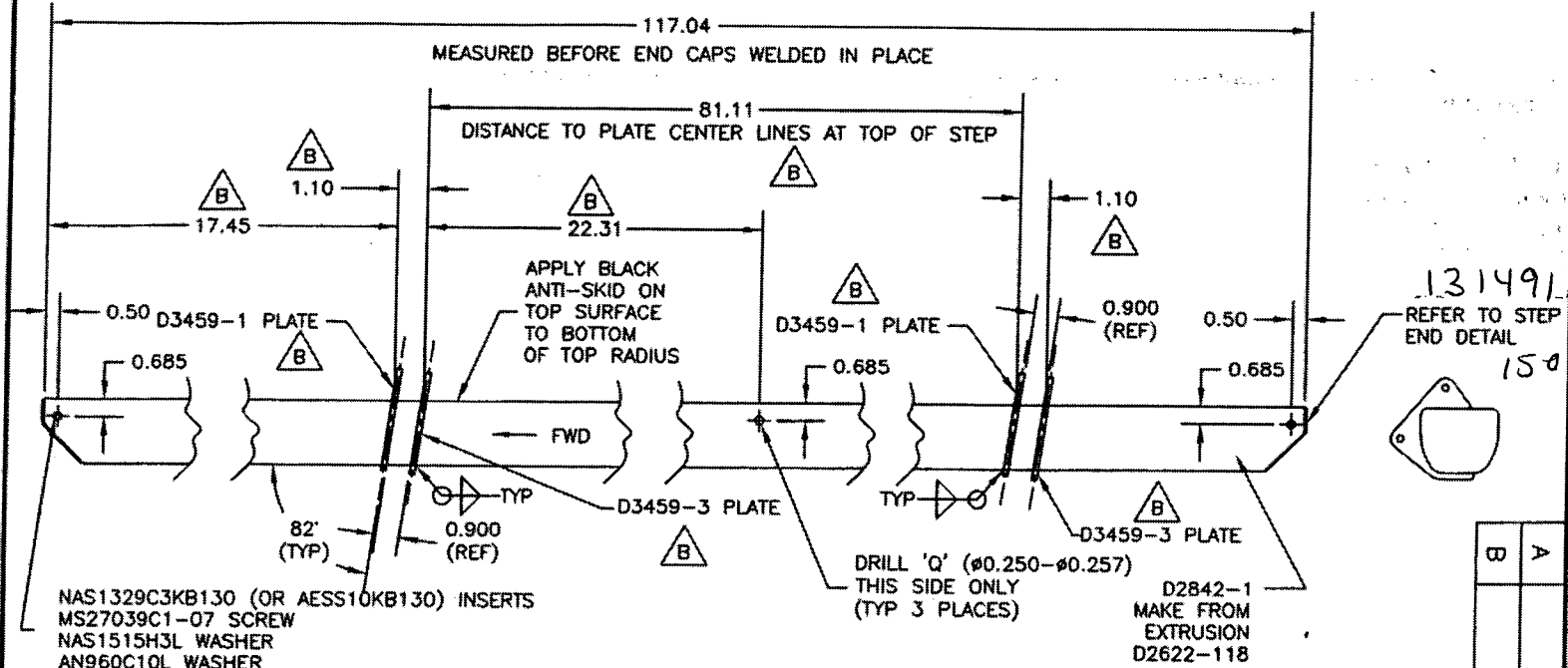
278

X6

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Shop Packet Print

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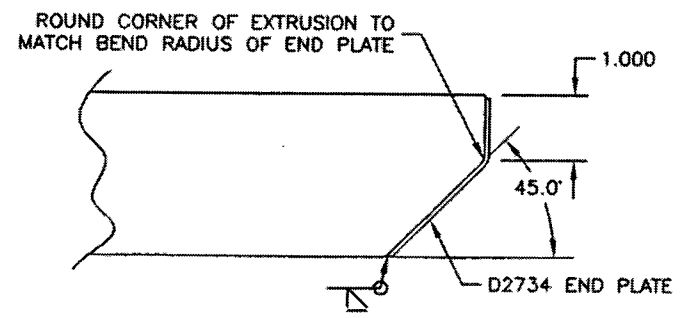
NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
05.11.14

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23	TITLE	D2842	REV. B
			206L/407 FLOAT STEP ASSEMBLY	SHEET 1 OF 1
			NEW ISSUE	SCALE
			RE-DESIGN, ADD D3459-1/-3	NIS

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